

Date: Thursday, 1/17/2008 3:30:58 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY
 Job Number : 36841
 Estimate Number : 10699
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3391025
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : D3391 REV G
 Previous Run : 36840 Project Number : N/A
 Material : G
 Due Date : 2/15/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC
 Est Rev C 06-03-28 Update Manuf. Instructions JLM
 est rev D 07.03.20 revF dwg EC
 est rev E 07.11.07 rev G dwg ecn 1053p EC verified
 by: DD
 Est Rev F 07-11-13 ECN 1056 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D6014-090 | Extrusion | 26546 |

Identify as D3391-3

RD 08/01/26

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: G & Dwg D3391 Rev: G

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/01/26 ①

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: G & Dwg D3391 Rev: G

2-Deburr

SA 08/02/20 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 01/01/00 | | | | | | | |
| 02/01/00 | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | 1 | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36841

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 68/02/20 (1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

AP 08-02-21 (1)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

EL 8-2-26

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 8-2-26

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 8-2-26

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'sink as per dwg D3391

6-Open up all wearshoe , wearplate and float bag holes as per Dwg D3391.

7-Deburr

Tools: rill

DP 8-2-26

DP 8-2-27

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36841

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/03 (X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.m 08.03.03 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-3-4

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: 35938

DP 8-3-4

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: M105379

exp. date: 8-5-30

cure time 12hrs as per QSI0015

DP 8-3-4

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/10 (X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

FL 08/03/10 (1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-11 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:58 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36841

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2646 | Aft Cap | B36184 |

H1

20.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B36714

H2

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B33869

H2

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33868

H2

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B32745

H2

24.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

B34470

H2

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: B105730

or equivalent per

QSI 017



H2 08-03-11

(21)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36841

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent

Per QSI 017

M100489

YL

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2

AN3C4A

Bolt

M107008

YL

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M106780

YL

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch

2

AN960C10L

Washer

M107242

YL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/291 M105585

Sikaflex expiry date: 08-07

YL

08-03-11

(X1)

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/2/12 (40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 2 Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:30:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36841

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/3/13 SQ



33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08/03/14 ①

Job Completion



2008/3/13 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--------------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 36841 |
| Description: Float Skidtube (412) | | Part Number: | D3391-3 |
| Inspection Dwg: D3391 Rev: G | | Page 1 of 1 | |

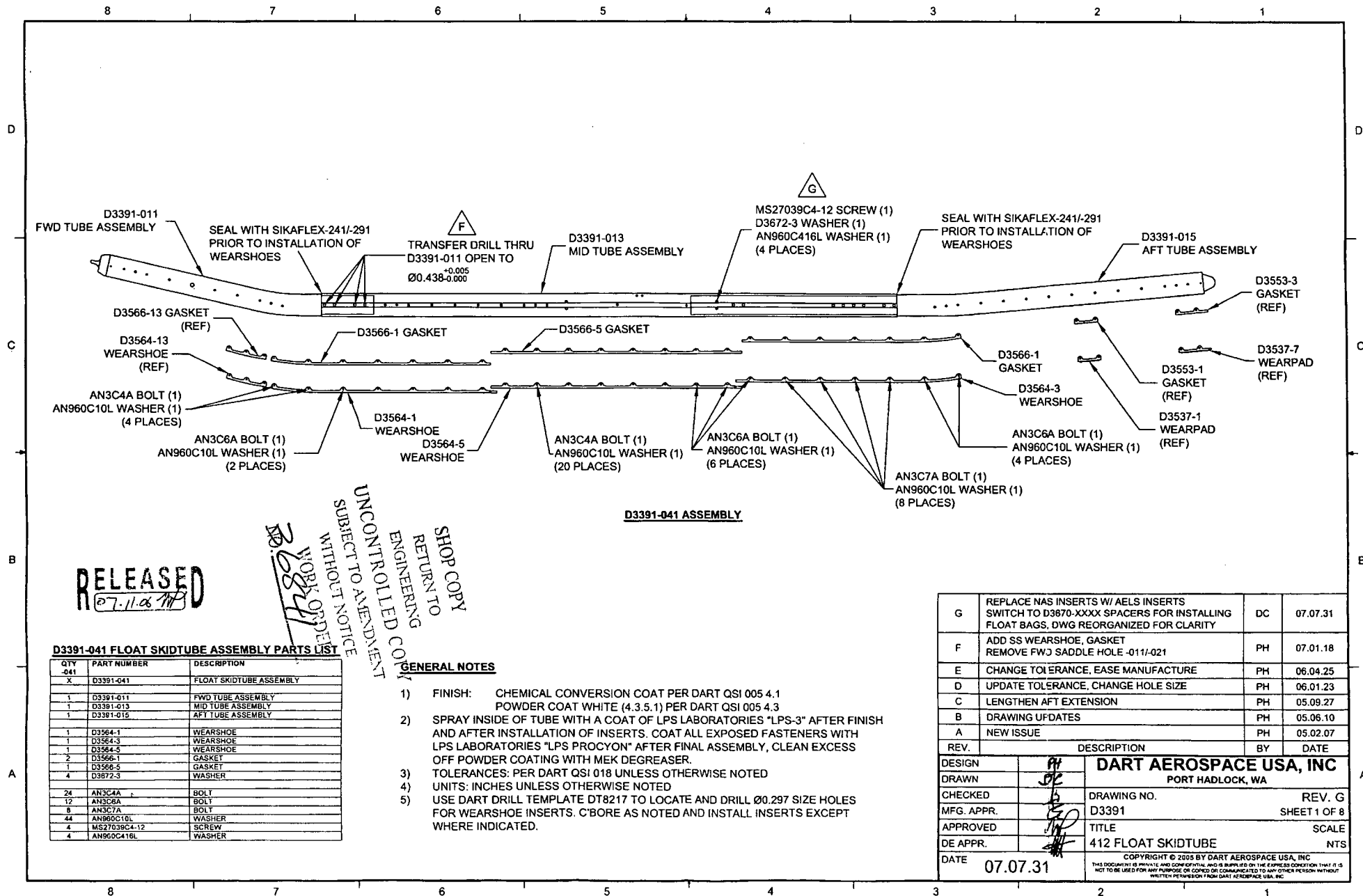
FIRST ARTICLE INSPECTION CHECKLIST

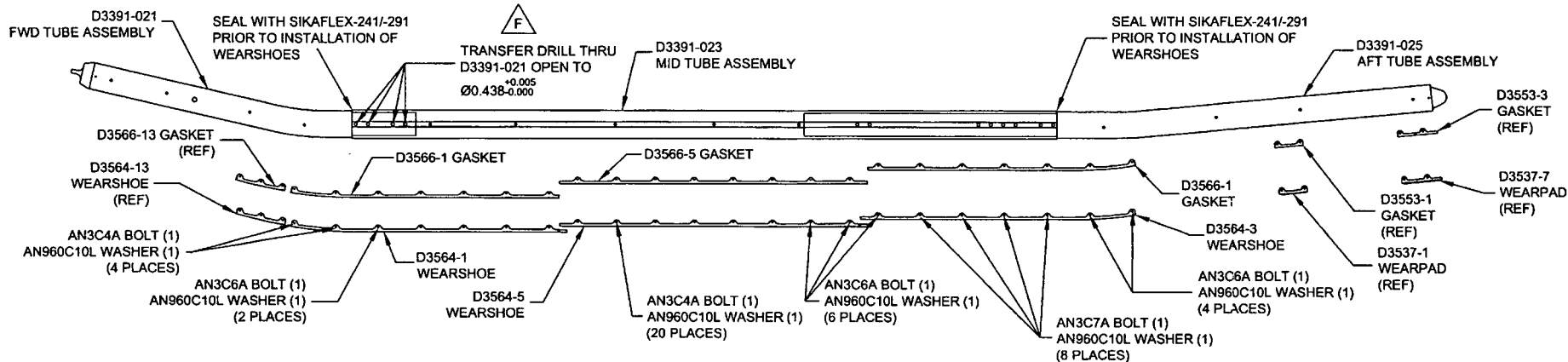
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 14.000 | +/-0.010 | 14.000 | / | | | |
| 3.500 | +/-0.010 | 3.502 | / | | | |
| 88.93 | +/-0.030 | 88.937 | / | | | |
| 44.995 | +/-0.030 | 44.993 | / | | | |
| 3.200 | +/-0.010 | 3.200 | / | | | |
| 1.526 | +0.000/-0.030 | 1.524 | / | | | |
| 0.200 | +/-0.010 | 0.201 | / | | | |
| 7.500 | +/-0.010 | 7.500 | / | | | |
| 27.750 | +/-0.010 | 27.750 | / | | | |
| 31.750 | +/-0.010 | 31.750 | / | | | |
| 35.250 | +/-0.010 | 35.250 | / | | | |
| 3.300 | +/-0.010 | 3.297 | / | | | |
| 0.200 | +/-0.010 | 0.199 | / | | | |
| 3.520 | +/-0.010 | 3.517 | / | | | |
| 0.687 | +0.010/-0.000 | 0.687 | / | | | |
| R0.062 | +/-0.010 | R0.062 | / | | | |
| Ø0.484 | +0.005/-0.001 | 0.488 | / | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-------------------------------|---------------------------------------|----------------------------|-----|
| Measured by: <i>SA</i> | Audited by: <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: 08/01/20 | Date: 08.02.21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|--------------------|
| A | 06.04.24 | New Issue P/O D3391-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | |
| C | 07.04.20 | Ø0.208 dimension removed | KJ/JLM | |
| D | 07.09.06 | 0.400 dimension removed | KJ/JLM | |
| E | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | <i>[Signature]</i> |





D3391-043 ASSEMBLY

RELEASED
07.11.21

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-------------------------|
| X | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 6 | AN3C7A | BOLT |
| 44 | AN960C10L | WASHER |

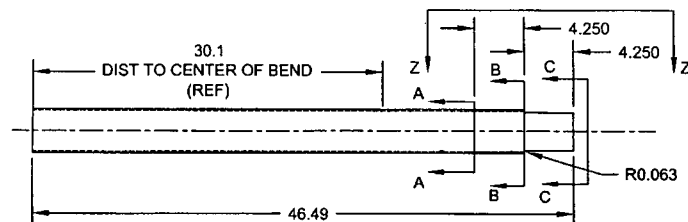
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

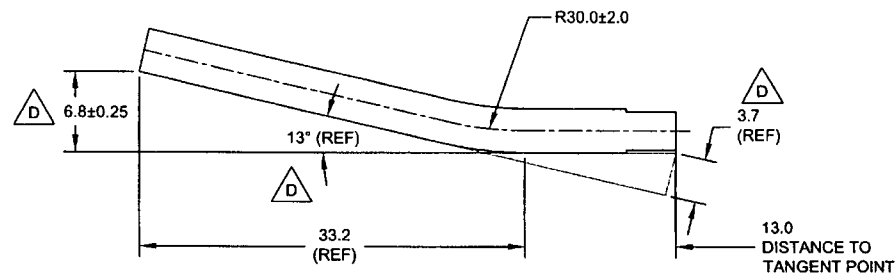
| | | |
|------------|----------|--------------------------------|
| DESIGN | PH | DART AEROSPACE USA, INC |
| DRAWN | JLC | PORT HADLOCK, WA |
| CHECKED | JLC | DRAWING NO. D3391 |
| MFG. APPR. | JLC | REV. G |
| APPROVED | JLC | SHEET 2 OF 8 |
| DE APPR. | JLC | TITLE 412 FLOAT SKIDTUBE |
| DATE | 07.07.31 | SCALE NTS |

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

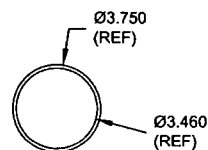
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 36841
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE



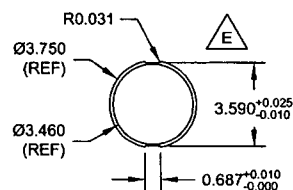
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



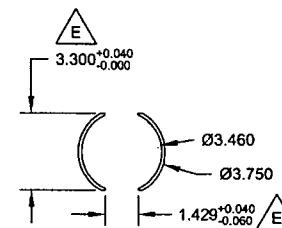
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



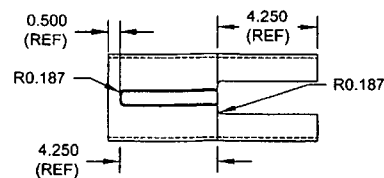
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

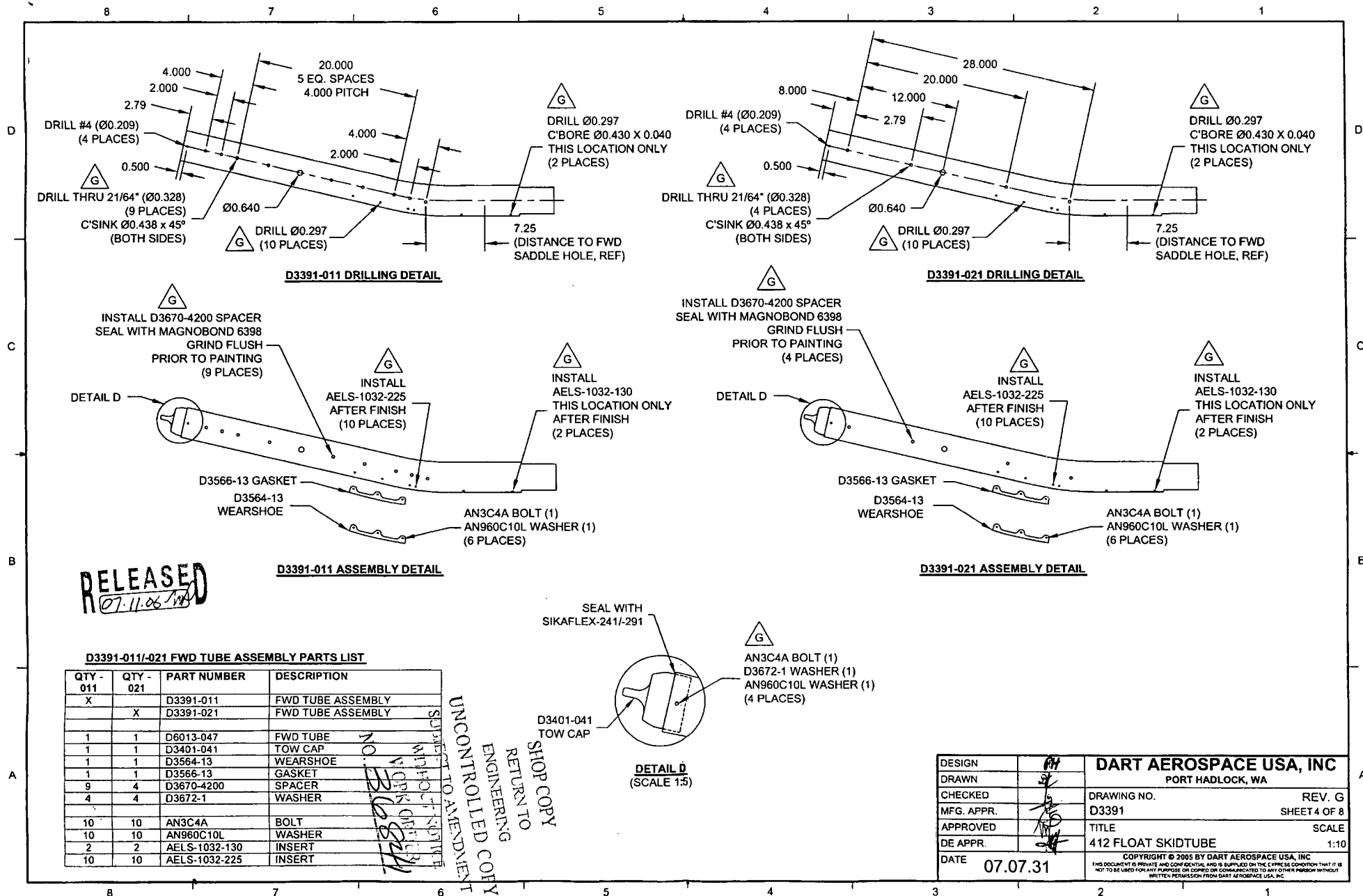


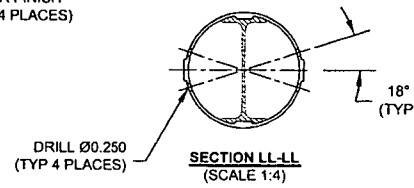
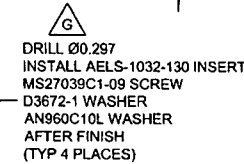
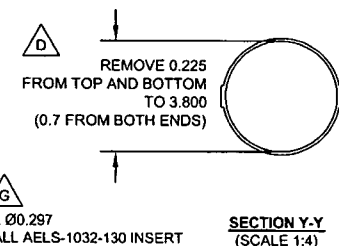
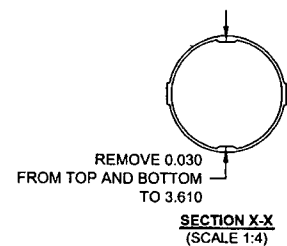
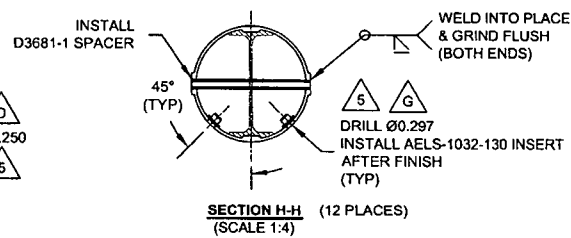
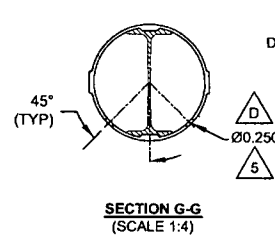
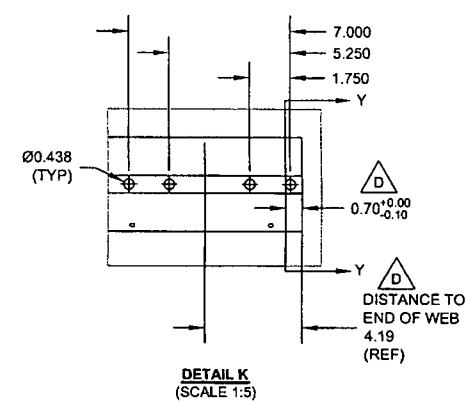
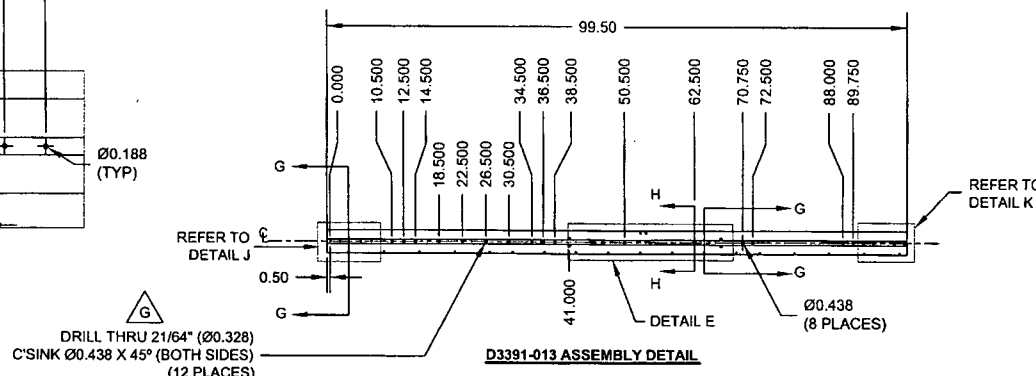
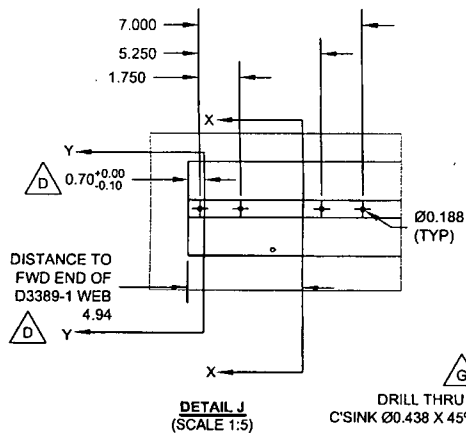
VIEW Z-Z
(SCALE 1:5)

RELEASED
27-11-26 MP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 36841
WORK ORDER

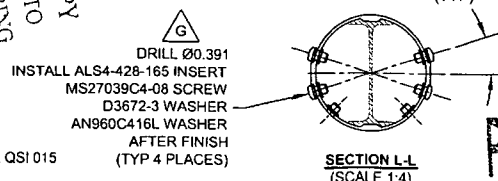
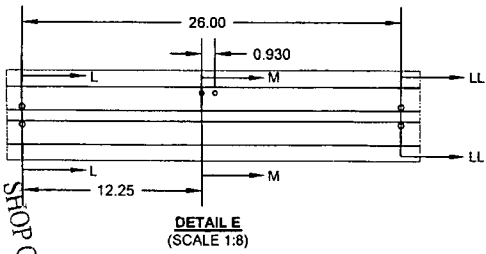
| | | | |
|------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | <i>GH</i> | DART AEROSPACE USA, INC | |
| DRAWN | <i>JLC</i> | PORT HADLOCK, WA | |
| CHECKED | <i>J</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>CE</i> | D3391 | SHEET 3 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 412 FLOAT SKIDTUBE | 1:1 |
| DATE | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |





D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY -013 | PART NUMBER | DESCRIPTION |
|----------|---------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 12 | D3681-1 | SPACER |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |



- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

| | | | |
|------------|----------|---------------------------------------------|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | JP | PORT HADLOCK, WA | |
| CHECKED | JP | DRAWING NO. | REV. G |
| MFG. APPR. | JP | D3391 | SHEET 5 OF 8 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | 412 FLOAT SKIDTUBE | 1:20 |
| DATE | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |

RELEASED

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 110871

